

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004765**Date Inspected:** 20-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Huan Wen-pang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

OBG Bay 3 UT/RT

This Caltrans QA Inspector arrived at ZPMC at Changxing Island for the continued observation of the SAS structure fabrication This QA inspector received notification for inspection and marking RT from ZPMC for side and edge plate CJP splices in bay 3. This QA Inspector performed UT verification for the CJP splice after ZPMC had completed and accepted the welds by UT. This QA Inspector's verification consisted of 10% of the weld lengths tested by ZPMC and found that the welds appeared to be within compliance at the time of review. The weldments tested by UT were EP064-001-015 and EP096-001-001 a TL-6027 will be generated for these locations. Components marked for RT testing by ZPMC were EP062-001-001 and EP094-001-001 these areas were marked with a length of 300mm so ZPMC could grind these areas prior to RT.

OBG Bay 7 UT

This Caltrans QA Inspector arrived at ZPMC at Changxing Island for the continued observation of the SAS structure fabrication This QA inspector received notification for inspection from ZPMC for Floor beams in bay 7. This QA Inspector performed UT verification for the CJP weld after ZPMC had completed and accepted the welds by UT. This QA Inspector's verification consisted of 10% of the weld lengths tested by ZPMC and found that the welds appeared to be within compliance at the time of review. The weldment tested was FB005-017-043, FB063-003-007 and 016, FB024-005-146,125 and 021, FB023-004-125 and 021, FB016-017-045, FB009-015-045, FB015-020-043, FB003-101-104 and 105, FB003-071-104 and 105, FB003-080-105, FB003-081-104 and 105, FB003-070-104 and 105, FB003-100-104 and 105. At the time of this QA inspectors review the welds appeared to

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be within compliance. A TL-6027 will be generated for these locations.

Tower Bay 3 Deck panels

The QA Inspector randomly observed ZPMC personnel performing grinding of repairs for the Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. This QA inspector along with ZPMC and ABF personnel performed the 3 party initial visual inspections. All 3 parties agreed that the repaired areas located were to be repaired and signed the yellow ABF tracking tag affixed to the deck panel. The deck panel inspected was DP385-001. Certified Welding Inspector for ZPMC Li Yan Hua was present at this location for the monitoring of the deck repairs and inspection. Also noted in bay 3 to monitor deck panel repairs were ABF personnel Wang Wei.

Summary of Conversations:

As noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Peter Dautermann, 1-500-219-9593, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
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Reviewed By:	Carreon, Albert	QA Reviewer
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